

Date: Friday, 10/13/2006 9:27:48 AM
 User: Kim Johnston

Process Sheet

SPLIT-2.

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 28961
 Estimate Number : 12470
 P.O. Number : N/A
 This Issue : 10/13/2006 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : MACHINED PARTS
 Previous Run : 27776
 Written By :
 Checked & Approved By :
 Comment : Est Rev:A New Issue 06-06-20 JLM

Drawing Name : PLUG
 Part Number : D3492047
 Drawing Number : D3492 REV B
 Project Number : N/A
 Drawing Revision : B
 Material : N/A
 Due Date : 11/5/2006

Qty: 20 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6R0500 6061-T6 Round Bar .500"



Comment: Qty.: 0.0656 f(s)/Unit Total : 1.3125 f(s)
 6061-T6 Round Bar .500" Dia.
 (M6061T6R0500)
 Batch: M102947

J.F. 06/10/28

2.0 HARDINGE HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA644 & Dwg D3492
 Dwg Rev: B
 Folio Rev: → new prog. no folio

MS 06/10/28 EC

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

MS 06/10/28 EC

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

MS 06/10/29 EC

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Debur

MS 06/11/10

x80

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLUG

Job Number: 28961

Part Number: D3492047

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

FLC 06/11/14 x 80

7.0 POWDER COATING POWDER COATING



Comment: POWDER COATING
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3
(Flat End Only)

FLC 06 11 23 (80)

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

ML 07/01/10 (80)

9.0 NAS1611007 O-RING



Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)

Qty Part Number Description Batch
1 NAS1611-007 O-RING

103272

FLC 07/02/13

10.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: Hand Finishing
2-Assemble O'Ring as per Dwg D3492 Applying some O'Ring Lube
A/R 55-O'Ring Lube Batch: *M1101223*

MS 07-03-08 (80)

11.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ML 07/01/10 11 07-03-08

12.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

U 07-03-09

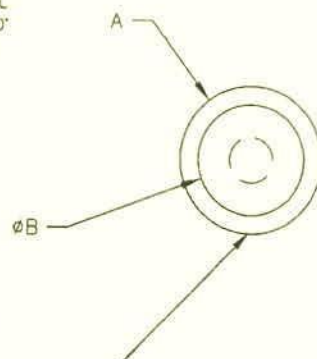
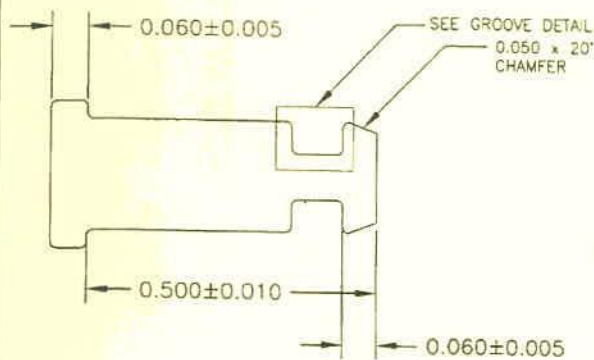
13.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(80) 07/03/09

U 07-03-09



D3492-1/-3/-5/-7 PLUGS IN ACCORDANCE WITH TABLE 1

GROOVE DETAIL

TABLE 1 D3492-1/-3/-5/-7 PLUG DIMENSIONS

P/N	A	B	C	MATERIAL SPEC
D3492-1	0.625	0.394	0.055	M6061T6R0.625
D3492-3	0.750	0.582	0.045	M6061T6R0.750
D3492-5	0.375	0.188	0.045	M6061T6R0.375
D3492-7	0.500	0.270	0.045	M6061T6R0.500

B

D3492-1/-3/-5/-7 PLUG NOTES

- 1) MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061T6R0.000)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTE
- 5) BREAK ALL SHARP CORNERS 0.010 MAX

D3492-1/-3/-5/-7 PLUG IN ACCORDANCE WITH TABLE 2

NAS1611-005/-007/-010/-013 O-RING IN ACCORDANCE WITH TABLE 2

D3492-041/-043/-045 PLUG ASSEMBLY

RELEASED
06.10.04
PER ECH #251

D3492-041/-043/-045 PLUG ASSEMBLY PARTS LIST
(TABLE 2)

Qty -041	Qty -043	Qty -045	Qty -047	Part Number	Description
X				D3492-041	PLUG ASSEMBLY
	X			D3492-043	PLUG ASSEMBLY
		X		D3492-045	PLUG ASSEMBLY
			X	D3492-047	PLUG ASSEMBLY
1				D3492-1	PLUG
	1			D3492-3	PLUG
		1		D3492-5	PLUG
			1	D3492-7	PLUG
		1		NAS1611-005	O-RING
			1	NAS1611-007	O-RING
1				NAS1611-010	O-RING
	1			NAS1611-013	O-RING

B

B

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B	06.05.11	ADD -047; UPDATE DIM A, -045
A	06.01.04	NEW ISSUE
DESIGN	06.01.04	NEW ISSUE
CHECKED	06.01.04	NEW ISSUE
DATE	06.05.11	PLUG
DRAWING NO.	D3492	
TITLE	PLUG	
REV. B		
SHEET 1 OF 1		
SCALE		
NTS		

